

Work Order ID 133111

Tuesday, May 26, 2015 12:44:36 PM

133111

Page 1

Item ID: D4895-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Outboard Beam Assembly
 Start Date: 5/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 26 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4895	B								

100' 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT BLANK AS PER FILE D4895-7_BLANK

(2)

05/25/27

110 0.00
110
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 MILL AS PER FOLIO FB330 AND DWG D4895
 FOLIO REV: AA
 DWG REV: 8
 DEBURR

1 1

DAS
20
9-89 15-06-09

DQA:

Date: 15/06/16

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~RPM~~

Date: 15/06/15

Work Order update only ☐

Work Order: <u>13311</u> Part No. <u>D4895-047</u> NCR No.		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Description Work Order Deviation <u>1/2" cutter caught on extra material used for clamping down part and marked one side of part.</u>				Disposition <u>Scrap + Destroy</u> <u>Replac. m 130527</u> <u>QTY 1</u> <u>(X)</u> <u>Add memo in folio outside bolts</u> <u>15-06-10</u>																																																																			
				Completed By <u>DAS</u> <u>20</u> <u>9-89</u> <u>15-06-09</u> Lead hand / Supervisor Approval Verification <u>08</u> <u>9-89</u> <u>B.A 15/06/10</u> QC / QA Coordinator Approval <u>9</u> <u>9-89</u> <u>15-06-10</u>																																																																			
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QA Closed: _____ Date: _____

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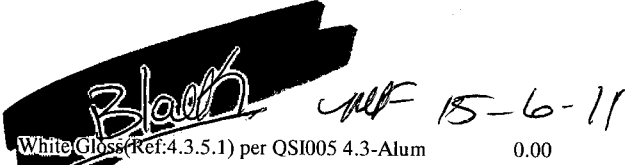
Tuesday, May 26, 2015 12:44:36 PM

133111

Page 3

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170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									
									
171	White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum	0.00							
171									
Powdercoat	Memo	0.00							
Powder Coating	MASK HOLES AS PER NOTE 8								
	START TIME: 10:05-								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 10:35-								
172	QC3- Inspect Part Finish	0.00							
172									
QC	Memo	0.00							
Quality Control									

DAS
30
9-89

JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order ID 133111

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Page 4

Item ID: D4895-047 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Outboard Beam Assembly
Start Date: 5/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/26/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180					DAS	1			
Small Fab	Memo	0.00			30				JUN 1 2015
Small Fab	PRESS FIT BUSHING AS PER DWG				989				
190									
190	QC5- Inspect part completeness to step on W/O	0.00				1			
QC	Memo	0.00							DAS
Quality Control									38
									989
									JUN 12 2015
200									
200	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									JUN 12 2015

PPP133272

[Handwritten Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 133111

Tuesday, May 26, 2015 12:44:36 PM

133111

Page 5

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

JUN 1 2 2015

MLJ

JUN 1 2 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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Page 1

Work Order ID: 133111

133111

Parent Item: D4895-047

D4895-047

Parent Item Name: Aft Outboard Beam Assembly

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4859-1		Manufactured	No				Each	18.0000		4			
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D4859-1

Bushing

**** DAS
30
9-89**

JUN 11 2015

Location

Loc Qty

Loc Code

ST132

18

122987

16

124826

2

f

37.8000

4

M6061T6B1.000X12.00
0

Purchased No

M6061T6B1 000X12 000

6061-T6 Bar 1.00 x 12.00

Dec 15/05/27

Location

Loc Qty

Loc Code

MAT007

37.8

123649

0.8

m115844

5

M126351

1.5

m130017

6.5

m130527

24

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : ☐																																																																				

DART AEROSPACE LTD		Work Order: 133111
Description: Aft Outboard Beam		Part Number: D4895-7
Inspection Dwg: D4895	Rev: B	Page 1 of 1

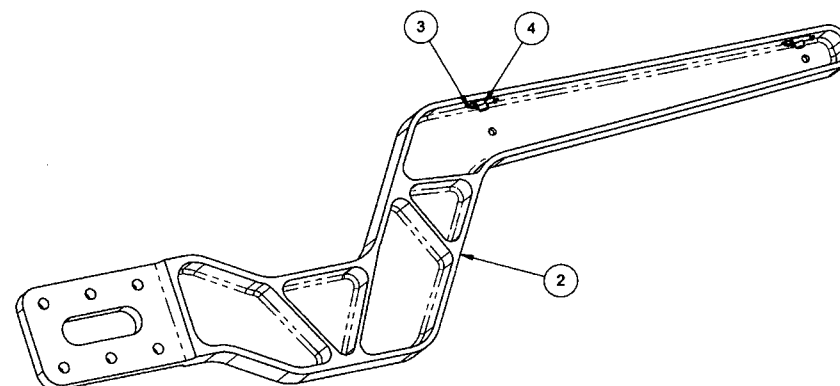
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550	✓	SL01	Tape
	R1.50	+/-0.030	1.500	✓	Rad	gauge
	R0.38	+/-0.030	.380	✓	"	
	4.63	+/-0.030	4.630	✓	Height	gauge
	5.75	+/-0.030	5.749	✓	SL08	VEKN
	0.250	+/-0.010	.249	✓	"	
	0.150	+/-0.010	.148	✓	"	
	3.00	+/-0.030	3.000	✓	"	
	R0.43	+/-0.030	.430	✓	Rad	gauge
	0.200	+/-0.010	.200	✓	SL08	
	0.750	+/-0.010	.747	✓	"	
	Ø0.425	+0.000/-0.002	.424	✓	gauge	Pin
	6.97	+/-0.030	6.971	✓	Height	gauge
	0.93	+/-0.030	.928	✓	SL08	
	0.85	+/-0.030	.846	✓	"	
	1.00	+/-0.030	.996	✓	"	
	R0.13	+/-0.030	.125	✓	Rad	gauge
	0.150	+/-0.010	.153	✓	SL02	MIC
	Ø0.377	+0.006/-0.001	.380	✓	gauge	Pin
	3.00	+/-0.030	2.999	✓	SL08	
	1.15	+/-0.030	1.148	✓	"	
	Ø1.00	+/-0.030	1.001	✓	"	
	2.300	+/-0.005	2.300	✓	"	
	0.60	+/-0.030	.599	✓	"	
	0.80	+/-0.030	.798	✓	"	
	3.600	+/-0.005	3.598	✓	"	
	1.800	+/-0.005	1.798	✓	"	
	1.75	+/-0.030	1.748	✓	"	
	3.50	+/-0.030	3.498	✓	"	
Manual Mill	0.25	+/-0.030	.247	✓	"	
	5.50	+/-0.030	5.501	✓	"	
	12.000	+/-0.005	12.000	✓	SL01	Tape
	1.55	+/-0.030	1.547	✓	SL08	
	Ø0.465 X 90°	+/-0.010 x 0.5°	.475 X 90°	✓	"	
	R0.25	+/-0.030	.250	✓	Rad	gauge
	0.500	+/-0.010	.500	✓	SL08	

Measured by: 20 9-89	Audited by: J.P. DAS 08	Preliminary Approval:
Date: 15-06-10	Date: 15/06/10 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4895-041	FWD OUTBOARD BEAM ASSY
2	1	D4895-1	FWD OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059-4	NUT PLATE



D4895-041 FWD OUTBOARD BEAM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.31 lbs

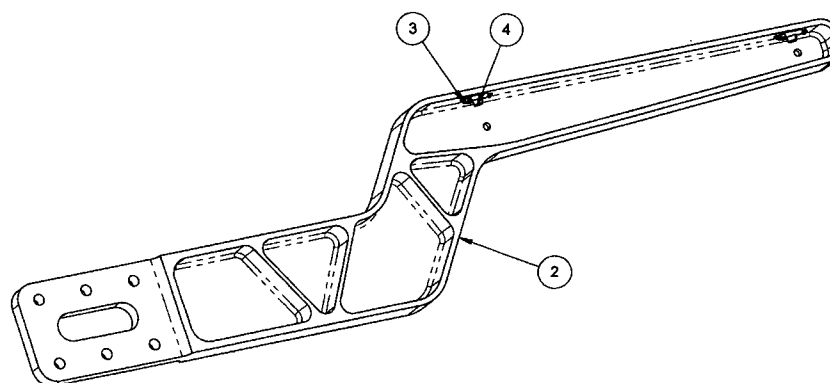
STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133111 MJS
150526

RELEASED
2014-07-24

B	ADD D4895-5/-7/-045/-047 (ZN A4-3, A4-4, A4-7, A4-8), ADD NOTE 9 (ZN A8-5, A8-6, A8-7, A8-8)	RF	14.04.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4895	SHEET 1 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD BEAM	NTS
DATE	14.04.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4895-043	AFT OUTBOARD BEAM ASSY
2	1	D4895-3	AFT OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059-4	NUT PLATE



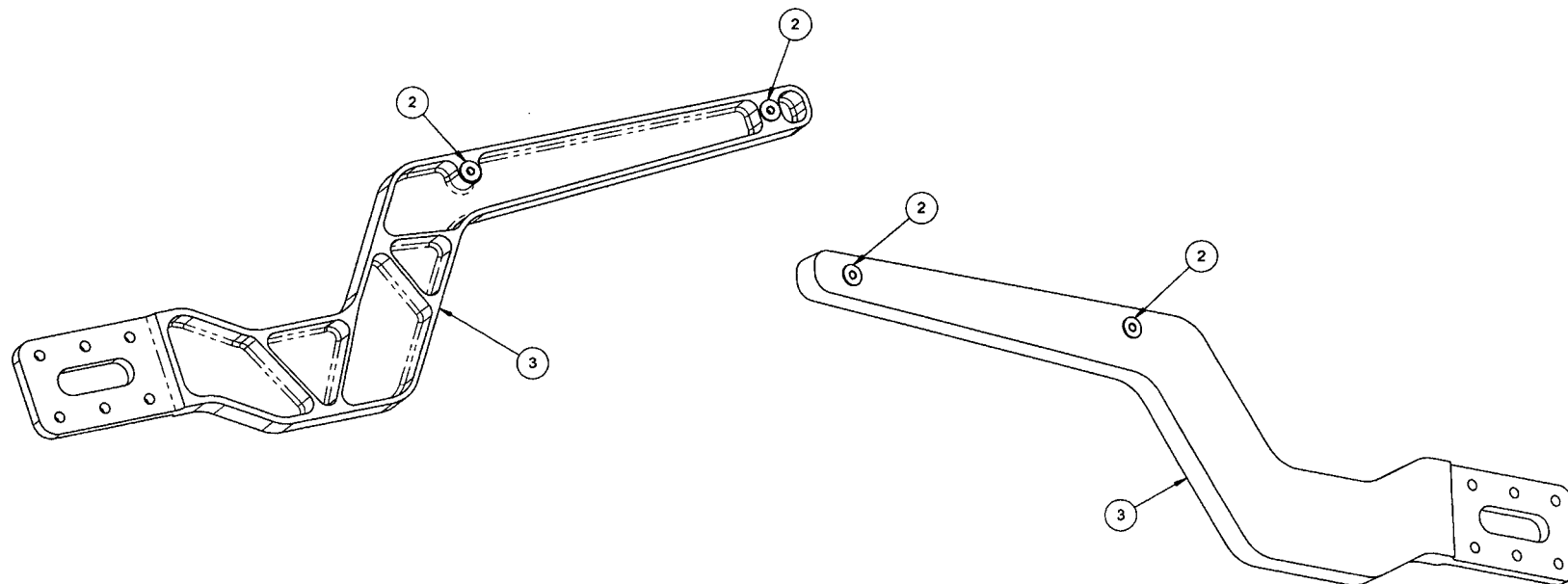
D4895-043 AFT OUTBOARD BEAM ASSY

RELEASED
2014-07-24
mp

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 3.25 lbs

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4895	SHEET 2 OF 9
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS-#	OUTBOARD BEAM	NTS
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ITEM	QTY -045	P/N	DESCRIPTION
1	X	D4895-045	FWD OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-5	FWD OUTBOARD BEAM



D4895-045 FWD OUTBOARD BEAM ASSY

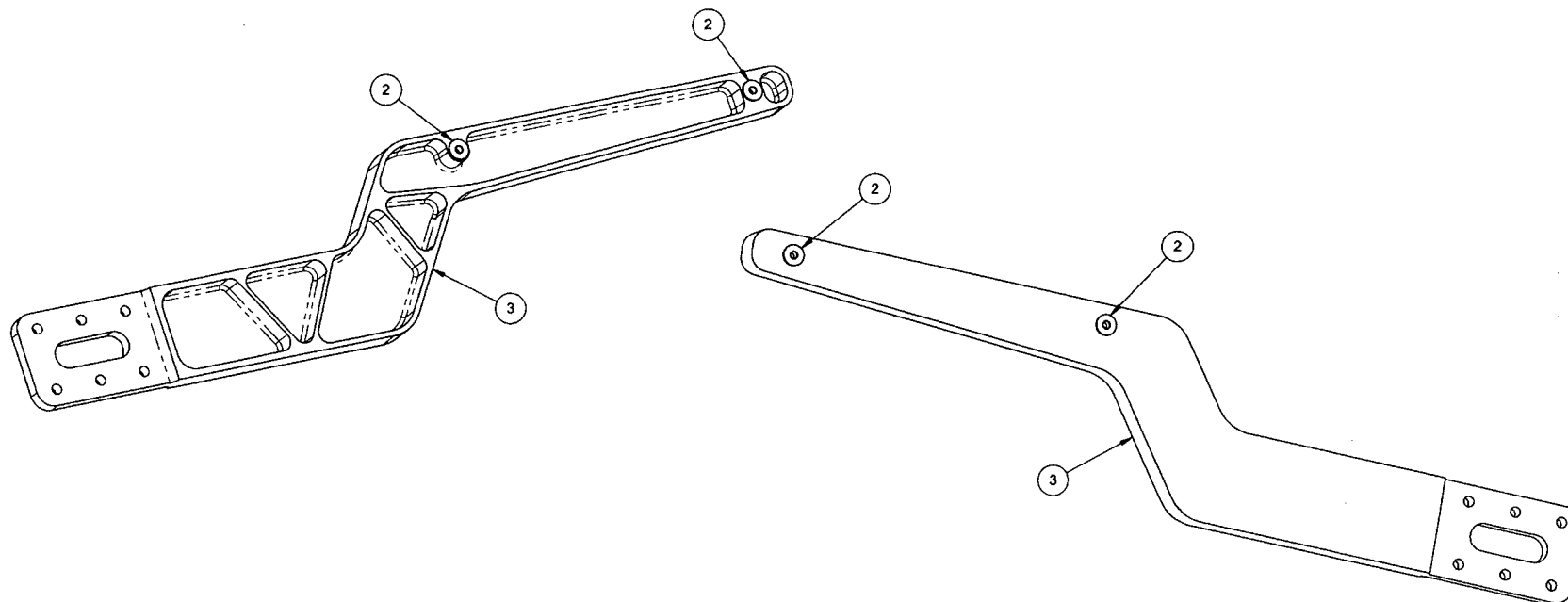
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.50 lbs
- 8) PRESS FIT D4859-1 INTO D4895-5. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

RELEASED
2014-07-24
mf

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4895	REV. B
	MFG. APPR.	JLM		SHEET 3 OF 9
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD BEAM	NTS
	DATE	14.04.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -047	P/N	DESCRIPTION
1	X	D4895-047	AFT OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-7	AFT OUTBOARD BEAM



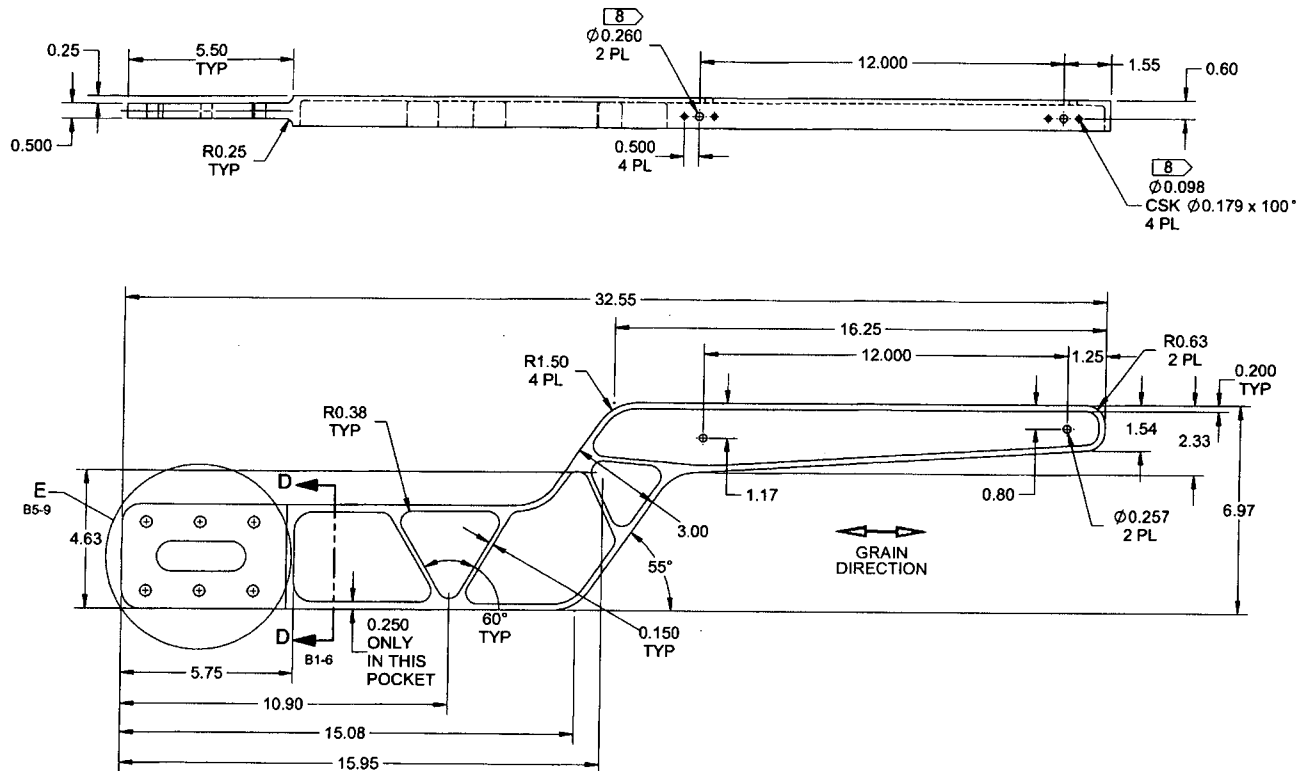
D4895-047 AFT OUTBOARD BEAM ASSY 

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.44 lbs
- 8) PRESS FIT D4859-1 INTO D4895-7. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

RELEASED
2014-07-24
MP

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4895	REV. B
	MFG. APPR.	JLM		SHEET 4 OF 9
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD BEAM	NTS
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D4895-3 AFT OUTBOARD BEAM

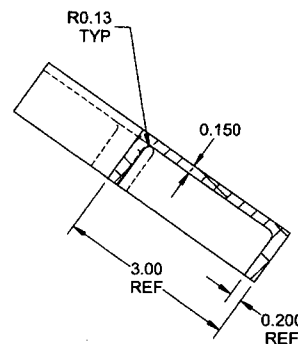
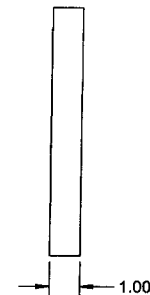
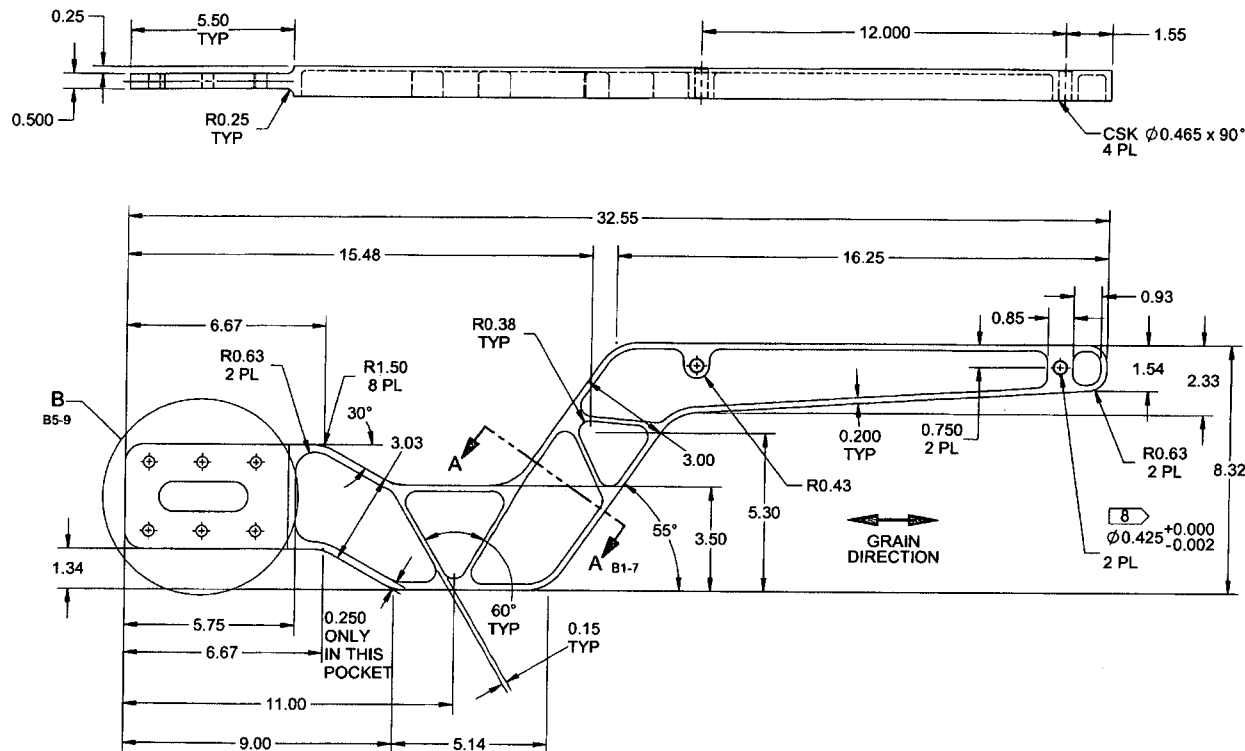
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.25 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-3.SLDPRT

RELEASED
2014-07-24

APPROVED	DESIGN	RF	DART AEROSPACE LTD	
	DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4895	SHEET 6 OF 9
	APPROVED	HS	TITLE	SCALE
	DE APPR.	D3	OUTBOARD BEAM	NTS
DATE		14.04.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



SECTION A-A C6-7

D4895-5 FWD OUTBOARD BEAM

NOTES:

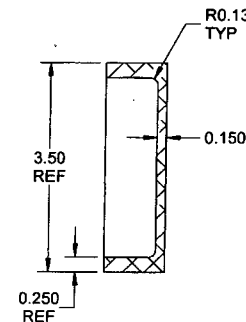
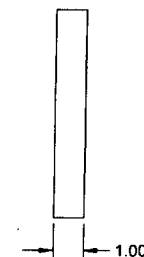
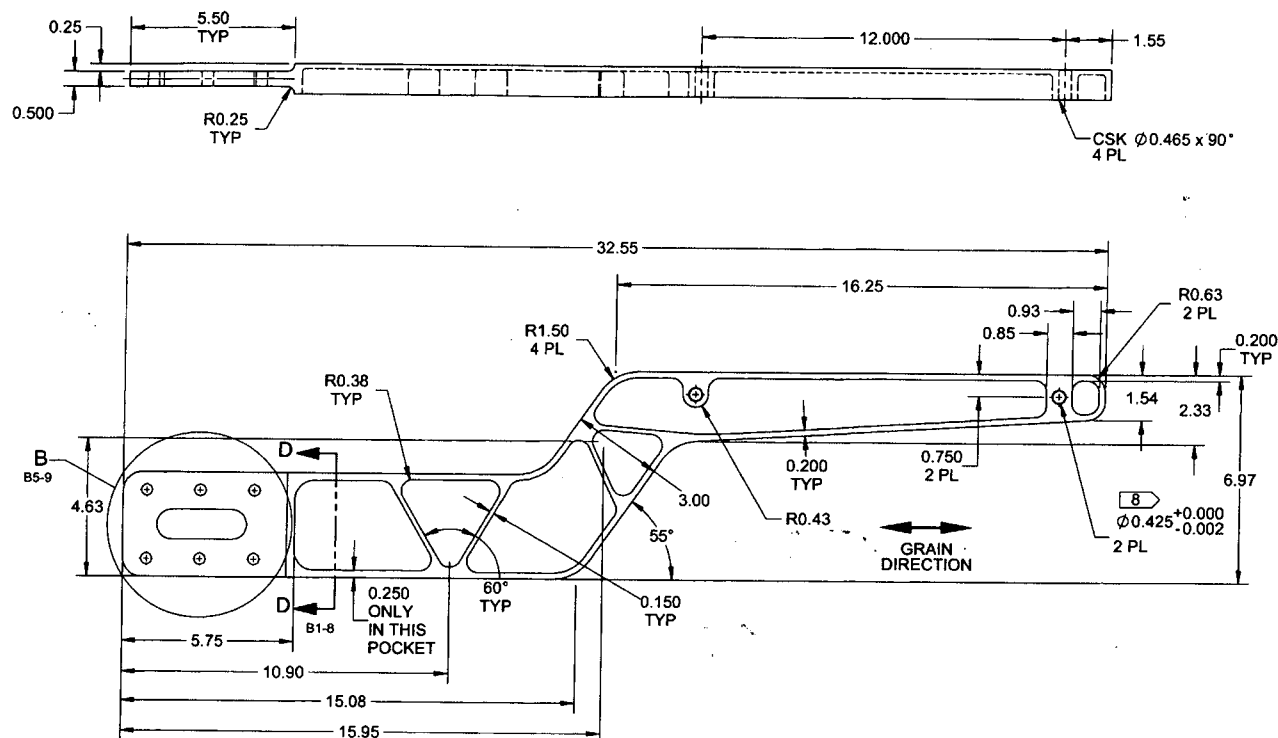
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.44 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-5.SLDPRT

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2014-07-24

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4895	REV. B
MFG. APPR.	JLM		SHEET 7 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD BEAM	NTS
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8 7 6 5 4 3 2 1



SECTION D-D B7-8

D4895-7 AFT OUTBOARD BEAM

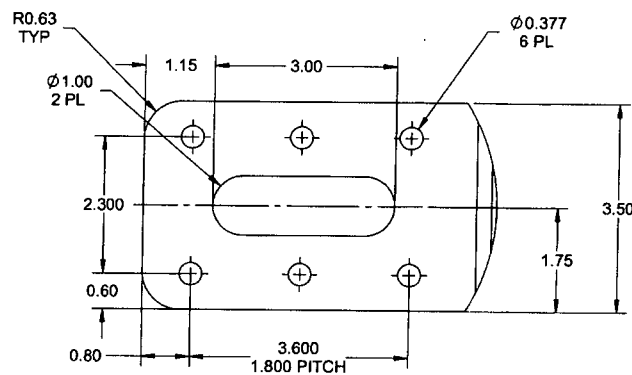
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.39 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-7.SLDPRT

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4895	REV. B
MFG. APPR.	JLM		SHEET 8 OF 9
APPROVED	HS	TITLE OUTBOARD BEAM	SCALE NTS
DE APPR.	DS		
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DETAIL B
C8-5
C8-6
C8-7
C8-8

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2014-07-24

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4895	REV. B
	MFG. APPR.	JLM	SHEET 9 OF 9	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD BEAM	NTS
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